

ASAP DO NOT ASSEMBLE

Date: Thursday, 18/10/2007 3:26:01 PM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 34270
Estimate Number : 12577
P.O. Number : N/A
This Issue : 18/10/2007 S.O. No. : N/A
Prsht Rev. : NC
First Issue : 27/08/2007 Type : LARGE FAB ASSY
Previous Run : 34027
Drawing Name : STEP WELDMENT
Part Number : D3562042
Drawing Number : D3562 UNDER REVIEW
Project Number : N/A
Drawing Revision : A
Material : N/A
Due Date : 07/09/2007 Qty: 6 Um: Each
Written By :
Checked & Approved By :
Comment : Est Rev A New Issue 06-11-09 JLM

Additional Product

Job Number:



PHS

Seq. #: Machine Or Operation: Description :

1.0 D2622120C Extrusion



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Qty Part # Description Batch:

1 D2622-120C Extrusion 34694

Check Material for any Dents or Defects

FF 07-10-31

6

2.0 D2734 206 Step Endplate

13.1



Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number Description Batch
2 D2734 End Cap 334485

FF 07-10-31

6

3.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2622 extrusion as per Dwg D3562

FF 07-10-31

2-Debur and bevel ends for welding

3-Weld (1)end cap as per Dwg D3562& QSI 004. Inspect for foreign objects as per QSI 024.

A/R Aluminum Rod

4-Grind end cap welds flush as per Dwg D3562

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07/10/08	16.0	ADD A STEP to allow the pre heating of the steps to be stable. SEND CAPS after welding 15 min @ 320°C to Dry off Dampers					07/10/08
07/11/12		Press Bushing D 2808 Batch B32896 in the arm.	MF	07-11-12	6		

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Drawing Name: STEP WELDMENT

Job Number: 34270

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Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

2 02/11/01

(26)

5.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

W

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

07-11-01

6

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

02/11/01

8.0

D3560042

ARM WELDMENT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

ARM WELDMENT

B 34475

07-11-02

6

9.0

D3560044

ARM WELDMENT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

ARM WELDMENT

Batch:

B 34477 = 5

B 35032 = 1

07-11-02

6

10.0

MS20600AD4W5

Blind Rivet



Comment: Qty.: 36.0000 Each(s)/Unit Total : 216.0000 Each(s)

Blind Rivet

batch:

M 105125 = 200

M 106074 = 16

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Drill Rivet holes as per dwg D3562.Touch up alodine.

07-11-02

6

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Drawing Name: STEP WELDMENT

Job Number: 34270

Part Number: D3562042

Job Number:



Seq. #:

Machine Or Operation:

Description :

Rivet legs using Magnabond as per dwg D3562.
Ensure to wipe off any excess magnabond of the step

A/R Magnabond 6398

Batch: M104677

07.11.08 6

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/11/06 6

13.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld Remaining end cap as per Dwg D3562& QSI 004. Inspect for foreign objects as per QSI 024.

A/R Aluminum Rod M105058

07-11-08 6

2-Grind end cap welds flush, as per Dwg D3562

FF 07-11-08 6

14.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 07-11-08 6

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/11/08 6

16.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

07-11-09 6

touch up alodine
pressure wash
M105194

07/11/08 6

17.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D3562 and QSI 005 4.4

Batch: M106030

07/11/12 6

18.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

7-11-12 6X

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Description :

19.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Package as step weldments only

do not assemble

draft TS 7/11/12 SQ 6x

20.0

QC21

FINAL INSPECTION/W/O RELEASE



(6)

Comment: FINAL INSPECTION/W/O RELEASE

208/11/14

Job Completion



U 87.11.13

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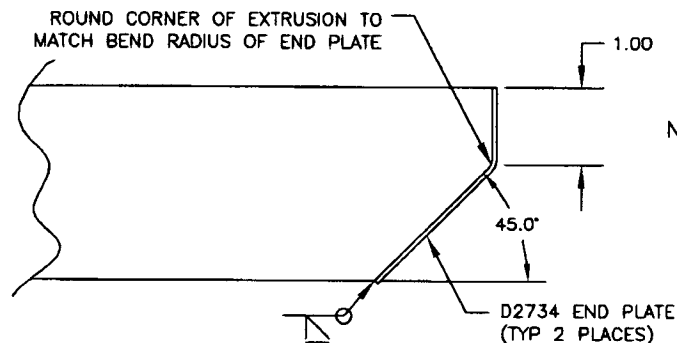
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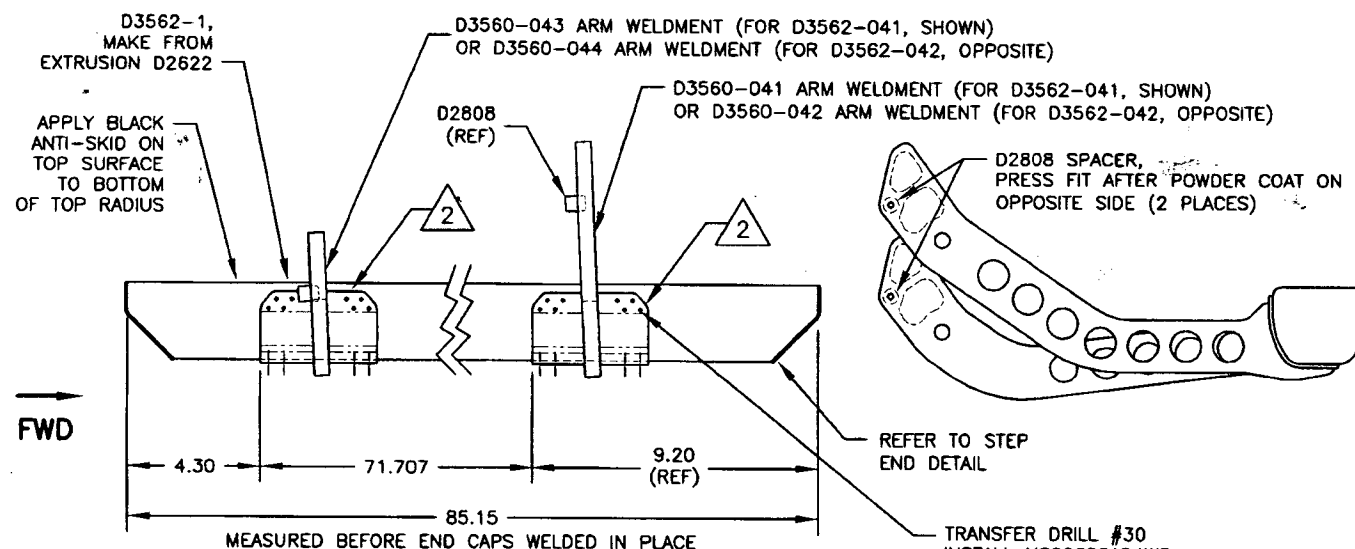
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DART**RELEASED**
07.06.24

TYPICAL STEP END DETAIL
NOT TO SCALE

NOTE: ALL WELDS SHALL BE 100% VISUALLY INSPECTED BY A QUALIFIED INSPECTOR PER DART QSI 004



D3562-041 LH STEP ASSEMBLY (SHOWN)
D3562-042 RH STEP ASSEMBLY (OPPOSITE)

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) INSTALL ARM WELDMENTS WITH A LAYER OF MAGNOBOND 6398 BETWEEN THE ARM WELDMENT AND STEP EXTRUSION. FILL ANY TOOLING HOLES WITH MAGNOBOND 6398. CLEAN OFF EXCESS BEFORE POWDER COATING.
- 3) WELD PER DART QSI 004
- 4) FINISH:
 - i) CHEMICAL CONVERSION COAT STEP EXTRUSION PER DART QSI 005 4.1 BEFORE ASSEMBLY
 - ii) POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6) OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3. TOUCH UP ANY UNFINISHED MAGNOBOND WITH PAINT PER DART QSI 005 4.2
 - iii) BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 5) ALL DIMENSIONS ARE IN INCHES

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED	APPROVED	DRAWING NO.	REV. C	
DATE		TITLE	SHEET 1 OF 1	SCALE
07.06.19		STEP ASSEMBLY		NTS
A	06.09.26	NEW ISSUE		
B	07.01.15	ARMS NOW RIVETED TO STEP		
C	07.06.19	NOW MAGBND, ADD D2808, RMV 4 RVTs		

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